



Dart Aerospace Ltd.
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D3283-1
Job Sheet 181226



Part No: D3283-1

Job Qty: 20 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP A 04.09.28 New issue KJ/JLM IPP Rev:B Now on Waterjet 07-05-28 JLM IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		8/31/18	0.00	0.00	Start Up Waterjet		<i>SC 18/08/18</i>
100	Waterjet	20 pcs		8/31/18	0.00	2.65	Waterjet1		<i>SC 18/08/18</i>
120	QC	20 pcs		8/31/18	0.00	0.00	QC8		<i>DR 18/08/18</i>
150	HandFinish	20 pcs		8/31/18	0.00	0.45	HandFinish1		<i>DR 18/08/18</i>
160	QC	20 pcs		8/31/18	0.00	0.00	QC7-2		<i>DR 18/08/18</i>
170	Packaging	20 pcs		8/31/18	0.00	0.00	Packaging3		<i>6 AUG 17 2018</i>
180	QC21-SA	20 Ea		8/31/18	0.00	0.00	QC21		<i>9-89</i>

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	4.7220 sf (.2361 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	5	139	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	14.750inches $\pm$ 0.010	14.760 14.740	<i>14,753</i>	
2	Doubler	10.634inches $\pm$ 0.010	10.644 10.624	<i>10,636</i>	
3	Doubler	1.250inches $\pm$ 0.010	1.260 1.240	<i>1,254</i>	
4	Doubler	1.250inches $\pm$ 0.010	1.260 1.240	<i>1,253</i>	
5	Doubler	1.500inches $\pm$ 0.010	1.510 1.490	<i>1,502</i>	
6	Doubler	3.000inches $\pm$ 0.010	3.010 2.990	<i>3,003</i>	
7	Doubler	1.170inches $\pm$ 0.010	1.180	<i>1,174</i>	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval _____		
Description Work Order Deviation				Disposition					
[Large blank area for description]				Completed By _____					
				and / Supervisor _____					
				al Verification _____					
				Coordinator _____					
				Approval _____					
Root Cause									
Environment ☐	No Re-verification ☐	Pressure/Force ☐							
Design ☐	Operator ☐	Bending ☐							
Doc/Data ☐	Offset/Setup ☐	Centre Not Cor ☐							
Equip/Tooling ☐	Supplier ☐	Cracks ☐							
Handling/Pre ☐	Training ☐	Crimp/Kink/Rip ☐							
Material ☐	Use for Testing ☐	Cuffs ☐							
Internal Transport ☐	Poor Information ☐	Crushing ☐							
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐							
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐			Mislabeled ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐			Fit/Function ☐			
Past Expiry Date ☐	Manufacturing Process ☐					Misaligned/off center ☐			
Misidentified ☐	Past Due ☐	OTHER : _____							

DART
AEROSPACE

Container No: S102258
Part: D3283-1
Job No: 181226
Serial No/Batch: S102258

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 08/14/18

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			1.160	
8	Doubler	0.710inches ± 0.010	0.720 0.700	0,713
9	Doubler	0.250inches ± 0.010	0.260 0.240	0,257
10	Doubler	1.420inches ± 0.010	1.430 1.410	1,428
11	Doubler	0.500inches + 0.006 - 0.001	0.506 0.499	0,501
12	Doubler	0.129inches + 0.005 - 0.001	0.134 0.128	0,129

Plex 7/24/18 9:40 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			